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D3078-042
Job Sheet 182702



Part No: D3078-042

Job Qty: 5 ea

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/30/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV:C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Large Fab-4		SLA
110	Large Fab	5 pcs	9/14/18	9/14/18	0.00	6.00	Large Fab 8		SLA
120	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC6		CPC
130	Large Fab	5 pcs	9/14/18	9/14/18	0.00	6.00	Large Fab 2		SA
140	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC9		SA
150	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC5		SA
160	HandFinish	5 pcs	9/14/18	9/14/18	0.00	1.04	HandFinish1		SA 18-09-13
170	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC7-2		CPC
200	Large Fab	5 pcs	9/14/18	9/14/18	0.00	6.00	Large Fab 2		DAS CPC
210	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC10		38 DAS
220	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC5		9-89 38
230	HandFinish	5 pcs	9/14/18	9/14/18	0.00	1.04	HandFinish6		DR 18/09/17
240	Powdercoat	5 pcs	9/14/18	9/14/18	0.00	0.95	Powdercoat1		BR 18-9-18
250	HandFinish	5 pcs	9/14/18	9/14/18	0.00	1.04	HandFinish3		AL 18-9-18
260	QC	5 pcs	9/14/18	9/14/18	0.00	0.00	QC3		DAS 6
290	Packaging	5 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-1		9-89 SEP 19 2018 68
300	QC21-SA	5 Ea	9/14/18	9/14/18	0.00	0.00	QC21		21 SEP 20 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Debur

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/RAluminum Rod 138 795 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

240 - START TIME: 11:30 OVEN TEMPERATURE: 300° FINISH TIME: 12:00

1183893

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2.5000 Ea (.5 ea)	90-Start up Operation	S104007
D3067-1	End Plate	5 Ea (1 ea)	130-Large Fab	S090880
D3219-3	Plate	10 Ea (2 ea)	130-Large Fab	S077386/S081006
D3065-041	Step Leg Assembly	5 Ea (1 ea)	200-Large Fab	S102056
D3066-1	Spacer	10 Ea (2 ea)	200-Large Fab	S077435

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

D3067-1
MS20600-AD4W4

End Plate
Rivet

5 Ea (1 ea)
80 Ea (16 ea)

200-Large Fab
200-Large Fab

S104284
3057529

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	3	199	0
130-Large Fab	D3067-1	5	183	0
	D3219-3	10	29	0
200-Large Fab	D3065-041	5	18	0
	D3066-1	10	110	0
	D3067-1	5	183	0
	MS20600-AD4W4	80	1,250	0

Part Specifications

Specifications could not be found.

Plex 8/30/18 10:37 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rewor _____ Scra _____ Use-as-i _____ Suspected Unapprove _____	DART AEROSPACE Container No: S107963 Part: D3078-042 Job No: 182702 Serial No/Batch: S107963 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/04/18																																																																																																																																																								
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